

762-011

Dart Aerospace Ltd.

Date: Monday, 16/03/2009 9:15:52 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BK117 SKIDTUBE ASSEMBLY
Job Number : 46499A	
Estimate Number : 12898	
P.O. Number :	Part Number : D117762041
This Issue : 16/03/2009 S.O. No. :	Drawing Number : D3582 REVA
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : SKIDTUBES	Drawing Revision : A
Previous Run : 46498A	Material :
Written By :	Due Date : 31/03/2009 Qty: 1 Um: Each
Checked & Approved By : <u>JUD 09-03-16</u>	
Comment : Est Rev:A 07.06.11 New Issue EC Est Rev:B 08-02-22 change to revA as per dwg DD verified by:EC	

Additional Product

Job Number:



Seq. #:

Machine Or Operation:

Description :

1.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile & type labels per PPP D117-762-041 CHG001

N/A

2.0

D2962150

3.540 Outer Tube, Extrud



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch

Extrusion

B28622

DP 9-3-16

3.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Determine square end of tube and deburr

2-Drill #30 pilot holes using DT8678.

3- open holes to 5/16"

MP

09-03-16

①

4.0

BENDING

BENDING MACHINE - SKIDTUBES



Comment: BENDING MACHINE

Bend tube as per program D3582 on CNC Bender and Dwg D3582. Use 5/16" locator pin on buggy "A".

MP 09-03-16 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Seq. #:

Machine Or Operation:

Description :

5.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Cut Fwd end of the tube using DT8185

DP 9-3-16

2-Cut Aft end using DT8185

3-Deburr ends

4-Drill Aft Cap holes using DT8678 ***DO NOT OPEN AFT CAP HOLE***

5-Locate DT 8973 & Drill Ground wire hole on top of Tube.

6-Install 3/16 cleco in Ground wire hole ,then drill all X-Bolt holes using 3/16" drill.

7-Drill pilot holes for wearplates using DT8974

8-Open wearplate holes to Ø19/64" (0.297") as per Dwg D3582.

9- open ground wear holes to 0.391" as per section B-B

10-Open Aft Cap holes using .209" drill.

11-Deburr holes.

Amc
69-03-17 (C)

6.0

D2964

Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch:

B14101

BE 09/04/07

7.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Weld fwd cap D2964 per dwg D3582 and QSI 004

A/R AL ROD

Batch:

m110676

BE 09/04/07

2-Grind flush

DP

9-4-7

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Job Number:



Seq. #:

Machine Or Operation:

Description :

8.0

QC10

VISUAL INSPECTION OF GROUND WELDS



8904000



Comment: VISUAL INSPECTION OF GROUND WELDS

9.0

QC5

INSPECT WORK TO CURRENT STEP



890408



Comment: INSPECT WORK TO CURRENT STEP

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

D M 9-4-8

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

D 9-4-8

12.0

D2971

Cross Bolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cross Bolt Spacer

batch *B44445* *D M 9-4-9*

13.0

D2973

Cross Bolt Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Cross Bolt Spacer

Batch: *B14636* *2 M 9-4-9*

14.0

D36621

Crossbolt Spacer



Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

SPACER

batch *B39525* *3 M 9-4-9*

15.0

D36623

Crossbolt Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

SPACER

batch *B44456* *D M 9-4-9*

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Job Number:



Seq. #:

Machine Or Operation:

Description :

16.0

D35841

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
WEB

B 416540 D 119-48

17.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open X-Bolt holes to .750"(4Places) as per Dwg D3582, section B-B

2-Counter Sink X-BOLT holes as per Dwg D3582

3-Deburr and blow out chips from inside of tube.

4-Bond web as per Dwg D3582 & QSI 015

A/R 241 Sike Flex Batch: M111081

Exp Date: 10-1-1

5-Weld x-bolt spacers(D2973) as per Dwg D3582 section B-B.

A/R AL ROD Batch: M110676 BE 24-9

6-Grind welds flush

fm 09-04-13 (D)

119-48

Tools: E

18.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 09/04/13 (X)

19.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 09/04/13 (X)

20.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

Pressure WASH LMS/BK M1100939

(X) 09/04/13

START TIME:

7:20

OVEN TEMPERATURE:

320°

FINISH TIME:

7:00

BK 09-04-24 (D)

W/O:		WORK ORDER CHANGES					
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Job Number:



Seq. #:

Machine Or Operation:

Description :

21.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-04-27

(X)

22.0

ALS41032130

Insert



Comment: Qty.: 36.0000 Each(s)/Unit Total : 36.0000 Each(s)

Insert

Batch: M1108606

JS

23.0

ALS4428165

Inserts



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Inserts

batch 116989

***same as ALS7-428-165 QSI 0017 ***

JS

24.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install Wearplate & Ground Wire inserts as per Dwg D3582.

JS

09-04-27

(X)

25.0

D2965

Cap, 105 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 1347235

JS

26.0

D35083

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 1342250

JS

27.0

D35089

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: B46596

JS

09-04-27

(X)

W/O:		WORK ORDER CHANGES					
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Job Number: 46499A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

28.0

D350811

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Batch: 1340398

WEARPLATE

jel

29.0

D350813

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARPLATE

Batch: 1342252

jel

30.0

D35583

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1345661

jel

31.0

D35589

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1340861

jel

32.0

D355811

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1340399

jel

33.0

D355813

Gasket



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: 1340400

jel

34.0

AN3C4A

BOLT



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

BOLT

Batch: 1111193

jel

09-04-27

(X)

W/O:		WORK ORDER CHANGES					
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Job Number: 46499A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

35.0

AN3C5A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M 111424

94

36.0

AN44A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

batch M 1108138

94

37.0

AN960C10L

washer



Comment: Qty.: 28.0000 Each(s)/Unit Total : 28.0000 Each(s)

washer

Batch: M 111424

94

38.0

AN960JD10L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch M 1109632

94

39.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Washer

batch M 1108583

94

40.0

NAS1611012

O-RING



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

O-RING

batch: M 1108673

94

41.0

NAS1611015

O-RING



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

O-RING

batch: M 1107178

94

09-04-27

94

W/O:		WORK ORDER CHANGES					
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Job Number: 46499A

Part Number: D117762041

Job Number:



Seq. #:

Machine Or Operation:

Description :

42.0

NAS1611016

O-RING



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

O-RING

batch: M107178

ll

43.0

D3492049

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

batch: 1344632

ll

44.0

D3492051

Plug Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

PLUG ASSEMBLY

batch: 1339723

ll

45.0

D3492053

Plug Assembly



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

PLUG ASSEMBLY

batch: 1344063

ll

46.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign objects

2-Install Aft cap as per Dwg D3582, Detail "C"

A/R 241 Sika Flex Batch: M111087

Exp Date: 10/20

3-Install Wearplates as per Dwg D3582 ,

Note: Install Bolt and washer on Ground Wire inserts on top of tube see section D-D of dwg D3582

*****Do not install bolts where indicated on Dwg(Note #6)*****

A/R 241 Sika Flex Batch: M111087

Exp Date: 10/20

4-assemble o-ring as per dwg D3492 and apply o-ring lube

A/R 55-o-ring lube batch: M101223

ll 09-04-27 (X)

W/O:		WORK ORDER CHANGES					
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Job Number: 46499A

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Job Number:



Seq. #:

Machine Or Operation:

3582 u

Description :

5- Wing Walk as per Dwg D3043 and QSI 005 4.4

m111013 -

09/04/27 (1)

47.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/04/28 (2)

48.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D117-762-041

Location:

PPP Rev:

PPP 46499

09/04/28 (1)

49.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/04/28 (2)

Job Completion



MF 09-04-28

W/O:		WORK ORDER CHANGES					
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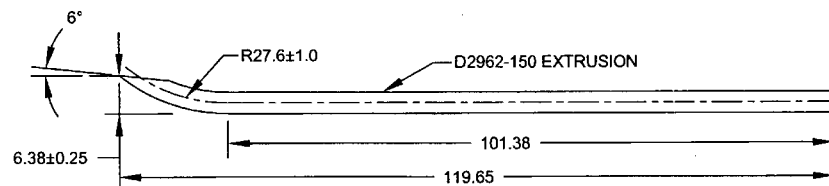
NOTE: Date & initial all entries

PARTS LIST FOR D3582-041 SKIDTUBE ASSEMBLY

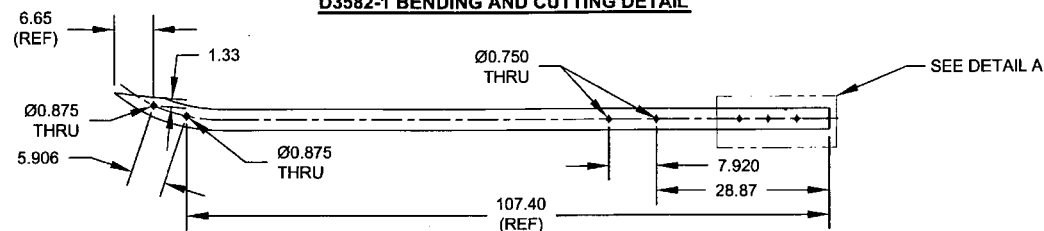
Qty	Part Number	Description
X	D3582-041	SKIDTUBE ASSEMBLY
1	D2962-150	EXTRUSION
1	D2964	CAP
1	D2965	CAP
1	D2971	CROSS BOLT SPACER
2	D2973	CROSS BOLT SPACER
2	D3492-049	PLUG ASSEMBLY
2	D3492-051	PLUG ASSEMBLY
6	D3492-053	PLUG ASSEMBLY
1	D3508-3	WEARPLATE
1	D3508-9	WEARPLATE
1	D3508-11	WEARPLATE
1	D3508-13	WEARPLATE
1	D3558-3	GASKET
1	D3558-9	GASKET
1	D3558-11	GASKET
1	D3558-13	GASKET
1	D3584-1	WEB
3	D3662-1	CROSS BOLT SPACER
1	D3662-3	CROSS BOLT SPACER
36	AELS-1032-130	INSERT
2	ALS7-428-165	INSERT
28	AN3C4A	BOLT
2	AN3-5A	BOLT
2	AN4-4A	BOLT
28	AN960C10L	WASHER
2	AN960JD10L	WASHER
2	AN960JD416L	WASHER

GENERAL NOTES:

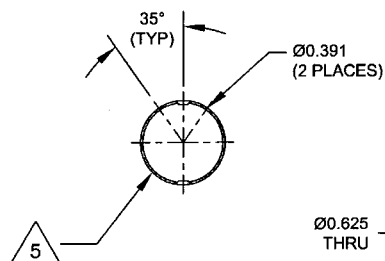
- ALL DIMENSIONS ARE IN INCHES
- TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- WELDING TO BE DONE PER DART QSI 004
- INSERT D3584-1 WEB TO LOCATION SHOWN OFF AFT END OF SKIDTUBE AND BOND WEB INTO OUTER TUBE WITH NON-STRUCTURAL SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015 AFTER BENDING.
- USE DART DRILL TEMPLATE DT8900 TO LOCATE AND DRILL Ø0.297 HOLES (36 PLACES) FOR WEARSHOE INSERTS. INSTALL AELS-1032-130 PER SECTION G-G (36 PLACES) AFTER FINISH. SEAL WEARPLATE BOLTS WITH SIKAFLEX-241/-291.
- DO NOT INSTALL AN3C4A BOLTS AND AN960C10L WASHERS IN INDICATED LOCATIONS.
- FINISH:
 - CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 PRIOR TO INSERTING D3584-1 WEB.
 - POWDER COAT ASSEMBLY GLOSS WHITE (REF 4.3.5.1) PER DART QSI 005 4.3.
 - ANTI-SKID PAINT AS INDICATED TO 1.00 ABOVE CENTER LINE PER DART QSI 005 4.4



D3582-1 BENDING AND CUTTING DETAIL



D3582-1 DRILLING DETAIL



SECTION B-B
SCALE 1:5

DETAIL A
SCALE 1:5

RELEASED
07.11.22

A	NEW ISSUE	PH	07.06.08
REV.	DESCRIPTION	BY	DATE
DESIGN	PA	DART AEROSPACE USA, INC	
DRAWN	PA	PORT HADLOCK, WA	
CHECKED	PA	DRAWING NO.	REV. A
MFG. APPR.	PA	D3582	SHEET 1 OF 2
APPROVED	PA	TITLE	SCALE
DE APPR.	PA	BK 117 SKIDTUBE ASSEMBLY	1:20
DATE	07.06.08	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC	

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NO WORK ORDER
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE

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NO. 169

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Barclay Elliot
Job number: 40355A
Part number: D117 762 041
Description: Bk 117 skid
Welding Process: Tig ☒ Mig ☐
Base material: Aluminium
Current: AC ☒ DC ☐

TEST REQUIREMENTS AND RESULTS

Visual: pass ☒ fail ☐
Penetration: pass ☒ fail ☐

UNACCEPTABLE

Cracks: pass ☒ fail ☐
Undercut: pass ☒ fail ☐
Pin holes: pass ☒ fail ☐
Overlap (cold lap): pass ☒ fail ☐
Porosity (surface): pass ☒ fail ☐
Coloration: pass ☒ fail ☐

Qualifier Det. Dymal Date of Test Coupon 08-08-21
Welder Barclay Elliot Date of Test Coupon 08-08-21

The above named individual is qualified in accordance with AWS D17.1.2001 to weld